WHAT IS CLAIMED IS:

1. A photosensitive composition comprising:

(a) 30-70% by weight of an epoxide-containing material;

(b) 5-35% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof;

(c) 0-40% by weight of a hydroxyl-containing material;

(d) at least one cationic photoinitiator; and

(e) at least one free-radical photoinitiator,

wherein said composition, after exposure to actinic radiation, has:

(i) an elongation at yield in the range of 7% to no yield;

(ii) a tensile modulus in the range of 1000 to 1600 N/mm^2;

(iii) an average elongation at break of at least 10%; or

(iv) a yield stress of 28 to 40 kN/mm^2.

2. The composition of claim 1, wherein the epoxide-containing material is selected from bis(2,3-epoxycyclopentyl)ether, 2,3-epoxy cyclopentyl glycidyl ether, 1,2-bis(2,3-epoxycyclopentyloxy)ethane, bis(4-hydroxycyclohexyl)methane diglycidyl ether, 2,2-bis(4-hydroxycyclohexyl)propane diglycidyl ether, diglycidyl ether of neopentyl glycol, 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexane, 3,4-epoxy-6-methylcyclohexylmethyl-3,4-epoxy-6-methylcyclohexanecaboxylate, di(3,4-

epoxycyclohexylmethyl)hexanedioate, di(3,4-epoxy-6-methylcyclohexylmethyl)hexanedioate, ethylenebis(3,4-epoxycyclohexanecarboxylate), ethanedioldi(3,4-epoxycyclohexylmethyl)ether, vinylcyclohexene dioxide, dicyclopentadiene diepoxide, 1,2-epoxytetradecane, a di(oxiranyl) poly(oxy-1,4-butanediyl), a partially acrylated bisphenol A epoxy, and 2-(3,4-epoxycyclohexyl-5,5-spiro-3,4-epoxy)cyclohexane-1,3-dioxane, and combinations thereof.

3. The composition of claim 1, wherein the acrylic material is selected from 1,4-dihydroxymethyl-cyclohexane diacrylate, bisphenol A diacrylate, trimethylolpropane triacrylate, and ethoxylated bisphenol A diacrylate and combinations thereof.

4. The composition of claim 1, wherein the hydroxyl-containing material is selected from 1,4-cyclohexanedimethanol, aliphatic and cycloaliphatic mono hydroxy alkanols, an aliphatic polycarbonate diol, and linear and branched polytetrahydrofuran polyether polyols, and combinations thereof.

5. The composition of claim 1, wherein the free-radical photoinitiator is a 1-hydroxyphenyl ketone.

6. The composition of claim 1, wherein the free-radical photoinitiator is selected from an alpha-hydroxyphenyl ketone, benzil dimethyl ketal or 2,4,6-trimethylbenzoyldiphenylphosphine oxide.

7. The composition of claim 1, wherein the composition comprises 32-48% by weight of an epoxide-containing material.

8. The composition of claim 1, wherein the composition comprises 10-20% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof.

9. The composition of claim 1, wherein the composition comprises 10-39% by weight of a hydroxyl-containing material.

10. The composition of claim 1, wherein the composition comprises 35-69.9% by weight of an epoxide-containing material, 10-20% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof, and 10-39% by weight of a hydroxyl-containing material.

11. The composition of claim 10, wherein the epoxide-containing material includes 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexane carboxylate, 1,2-epoxytetradecane, diglycidyl ether of neopentyl glycol, or α-(oxiranylmethyl)-ω-(oxiranylmethoxy) poly(oxy-1,4-butanediyl), or combinations thereof.

12. The composition of claim 1, wherein the hydroxyl-containing material includes a polytetrahydrofuran polyol, 1,4-cyclohexanedimethanol, or an aliphatic polycarbonate diol, or combinations thereof.

13. A three-dimensional article formed from a photosensitive composition comprising:

(a) 30-70% by weight of an epoxide-containing material;

(b) 5-35% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof;

(c) 0-40% by weight of a hydroxyl-containing material;

(d) at least one cationic photoinitiator; and

(e) at least one free-radical photoinitiator,

wherein the article has:

(i) an elongation at yield in the range of 7% to no yield;

(ii) a tensile modulus in the range of 1000 to 1600 N/mm^2;

(iii) an average elongation at break of at least 10%; or

(iv) a yield stress of 28 to 40 kN/mm^2.

14. The article of claim 13, wherein the composition comprises 35-69.9% by weight of an epoxide-containing material, 10-20% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof, and 10-39% by weight of a hydroxyl-containing material.

15. The article of claim 13, wherein the epoxide-containing material includes 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexane carboxylate, 1,2-epoxytetradecane, diglycidyl ether of neopentyl glycol, or α-(oxiranylmethyl)-ω-(oxiranylmethoxy) poly(oxy-1,4-butanediyl), or combinations thereof.

16. The article of claim 13, wherein the hydroxyl-containing material includes a polytetrahydrofuran polyol, 1,4-cyclohexanedimethanol, or an aliphatic polycarbonate diol, or combinations thereof.

17. A process for forming a three-dimensional article comprising:

(1) coating a layer of a composition onto a surface, the composition comprising:

(a) 30-70% by weight of an epoxide-containing material;

(b) 5-35% by weight of an acrylic material selected from aromatic acrylic material, cycloaliphatic acrylic material, or combinations thereof;

(c) 0-40% by weight of a hydroxyl-containing material;

(d) at least one cationic photoinitiator; and

(e) at least one free-radical photoinitiator,

(2) exposing the layer imagewise to actinic radiation to form an imaged cross-section, wherein the radiation is of sufficient intensity to cause substantial curing of the layer in the exposed areas;

(3) coating a layer of the composition onto the previously exposed imaged cross-section;

(4) exposing said thin layer from step (3) imagewise to actinic radiation to form an additional imaged cross-section, wherein the radiation is of sufficient intensity to cause substantial curing of the thin layer in the

exposed areas and to cause adhesion to the previously exposed imaged cross-section;

(5) repeating steps (3) and (4) a sufficient number of times in order to build up the three-dimensional article,

wherein the article has:

(i) an elongation at yield in the range of 7% to no yield;

(ii) a tensile modulus in the range of 1000 to 1600 N/mm^2;

(iii) an average elongation at break of at least 10%; or

(iv) a yield stress of 28 to 40 kN/mm^2.

18. The process of claim 17, wherein the actinic radiation is in the range of 280-650 nm.

19. The process of claim 17 wherein the exposure energy is in the range of 10-150 mJ/cm.

20. The process of claim 17, wherein the epoxide-containing material includes 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexane carboxylate, 1,2-epoxytetradecane, diglycidyl ether of neopentyl glycol, or α-(oxiranylmethyl)-ω-(oxiranylmethoxy) poly(oxy-1,4-butanediyl), or combinations thereof and the hydroxyl-containing material includes a polytetrahydrofuran polyol, 1,4-cyclohexanedimethanol, or an aliphatic polycarbonate diol, or combinations thereof.